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D119-827-011

Job Sheet 166556



Part No: D119-827-011

Job Qty: 1 ea

Part Name: Tail Rotor Pedal Lockout



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/11/17

Job Tracking No:

Due Date: 10/25/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Customer: Agustawestland Philadelphia Corp (CAGUS02)

3050 Red Lion Road Philadelphia, PA, 19114 USA ph:(215) 281-1400 fx:(215) 281-0447.

Note: DWG REV E IPP REV:A 12.10.16 AS PER DWG REV.A DD VERF:JFS IPP REV:B 13-01-09 REV B JLM
VERIFIED:DD IPP REV:C 12.10.16 as per CHG002 (ecn 13-538) DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	10/25/17	0.00	0.00	Start up container	
100	DC	1 pcs	10/25/17	0.00	0.00	DC	
110	Packaging	1 pcs	10/25/17	0.00	0.00	Packaging1	
120	QC	1 pcs	10/25/17	0.00	0.00	QC4	
130	Packaging	1 pcs	10/25/17	0.00	0.00	Packaging3	
140	QC21-FG	1 Ea	10/25/17	0.00	0.00	QC21	

Part Op 100 - Photocopy bluefile & type labels per PPP D119-827-011 CHG002

Descriptions: 130 - Identify and pack for shipping as per PPP D119-827-011

NOV 07 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation x1 5006103	AN4-11A 1-m 138170-35	2	169	0	0
	D4703-041 5006081	2	5	0	0
	D4704-041 5005744	1	0	0	0
	D4710-1 5006072	1	2	0	0
	D4721-1 5006072	1	5	0	0
	MS14144L4 5006075	2	6	0	0
	MS24665-153 5006076	2	20	0	0
	NAS1149D0416J 5006083	2	3,000	0	0
	NAS1149D0463J 5006071	8	1,118	0	0
	NAS6604D16 5006070	2	7	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS				
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____

Step #: _____

QTY Effective : _____

MRB (QS1042) Approval

Description Work Order Deviation

**S006100****Tail Rotor Pedal Lockout**

Dart Aerospace Ltd.
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Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval

PART NO:
Revision:
Operation:
Quantity:
Change No:

D119-827-011

Start up Operation
1

Mfg Date: 11/06/17
Job No: 166556

Root Cause		OTHER :	
Environment ☐	No Re-verification ☐	Pr ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Be ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Ce ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cr ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crir ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cu ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crush ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐		

REVISION ONLY

4.0 PARTS LIST

QTY -011	QTY -013	Part Number	Description
X		D119-827-011	TAIL ROTOR PEDAL LOCKOUT
	X	D109-827-013	TAIL ROTOR PEDAL LOCKOUT
2		D4703-041	LOCKOUT PIN ASSY
	1	D4703-045	LOCKOUT PIN ASSY
1		D4704-041	EXPANDABLE PIN ASSY
	1	D4704-043	EXPANDABLE PIN ASSY
1	1	D4710-1	SPACER
1	1	D4721-1	DECAL
	2	D5481-041	PLUG ASSEMBLY
2		AN4-11A	BOLT
	2	AN4H11A	BOLT
2		MS14144L4	NUT
2		MS24665-153	COTTER PIN
2		NAS1149D0416J	WASHER
8	2	NAS1149D0463J	WASHER
2		NAS6604D16	BOLT

5.0 WEIGHT AND BALANCE

Installation	Weight	Longitudinal		Lateral	
		Arm	Moment	Arm	Moment
D119-827-011 (A109/A119) Tail Rotor Pedal Lockout	0.52 lb 0.23 kg	32.6 in 0.83 m	16.9 in-lb 0.19 m-kg	-13.1 in -0.33 m	-6.8 in-lb -0.08 m-kg
D119-827-011 (206/407) Tail Rotor Pedal Lockout	0.52 lb 0.23 kg	33.0 in 0.84 m	17.2 in-lb 0.19 m-kg	-12.5 in -0.32 m	-6.5 in-lb -0.07 m-kg
D109-827-013 (AW109SP) Tail Rotor Pedal Lockout	0.54 lb 0.24 kg	32.6 in 0.83 m	17.6 in-lb 0.20 m-kg	-13.1 in -0.33 m	-7.1 in-lb -0.08 m-kg